

# Del 1.25 Work Order ID 68972

Tuesday, April 26, 2011 2:28:48 PM



Page 1

Item ID:	D3417-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Washer					
Start Date:	4/26/2011	Start Qty:	40.00			
Required Date:	4/29/2011	Req'd Qty:	40.00			
Reference:						

Approvals:	Process Plan:		Date:	11-07-14	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3417	Rev E								

100		0.00							
	Hardinge CNC LATHE SMALL								
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Folio FA761 Rev: <u>ME</u> & <u>E</u> Dwg D3417 Rev: <u>E</u> 2-Debur								
		11/18/7							

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
		11/15/7							

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									
		11/05/09							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68972**

Tuesday, April 26, 2011 2:28:48 PM



Page 2

Item ID: D3417-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 4/26/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>053</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

4/26/11 (40)

11/5/11

ME  
11-05-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 26, 2011 2:28:53 PM

Page 1

Work Order ID: 68972



Parent Item: D3417-5



Parent Item Name: Washer

Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A ☐ New issue ☐ 08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500 		Purchased	No			110	f	20.0840	0.0296	1.246316			
DELRIN ROUND BAR 1.25"													

Location

Loc Qty

Loc Code

MAT055

20.084

114586

20.084

*Handwritten notes:*  
11/5/8  
1.5 ft

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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES						
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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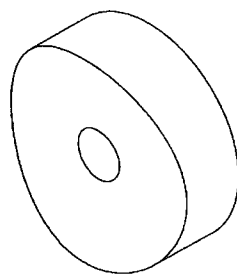
NOTE: Date & initial all entries



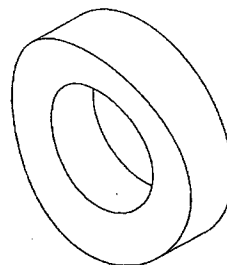
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 68972

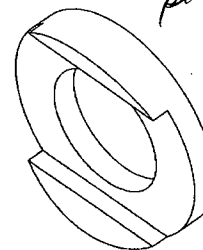
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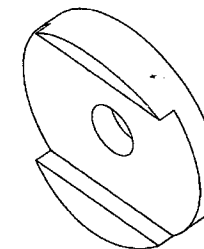
D3417-1 WASHER



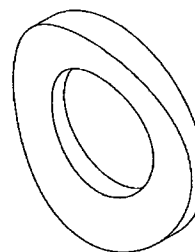
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



D3417-9 WASHER

RELEASED  
2010-09-15

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD  
REF DART SPEC M-DELIN-R  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR  
REF DART SPEC M-DELIN-B  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET  
REF DART SPEC M-DELIN-S

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: D3417-1, 0.020 lbs  
D3417-3, 0.010 lbs  
D3417-5, 0.010 lbs  
D3417-7, 0.010 lbs  
D3417-9, 0.004 lbs

REV.	DESCRIPTION	BY	DATE
F	ADD D3417-8 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -S WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS. REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3417	
CHECKED		REV. F	
MFG. APPR.		SHEET 1 OF 3	
APPROVED		TITLE WASHER	
DE APPR.		SCALE NTS	
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

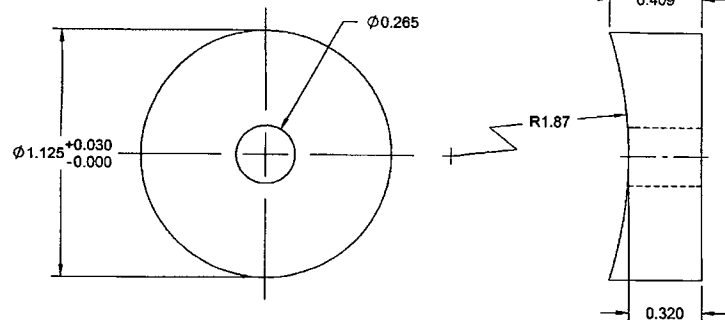
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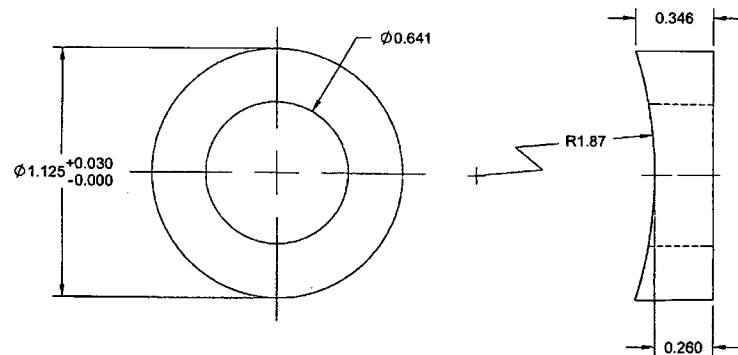
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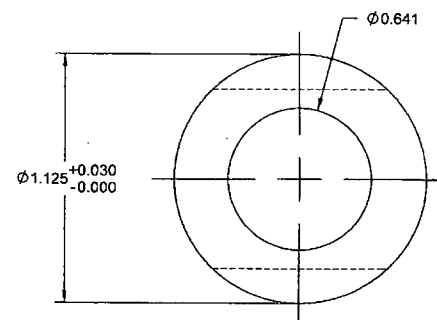
**NOTE:** Date & initial all entries



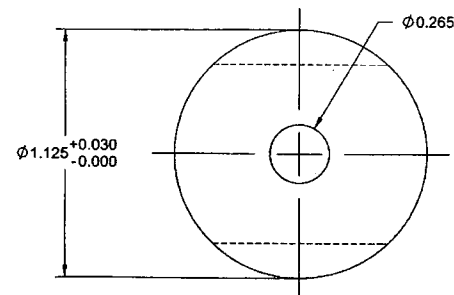
**D3417-1 WASHER**



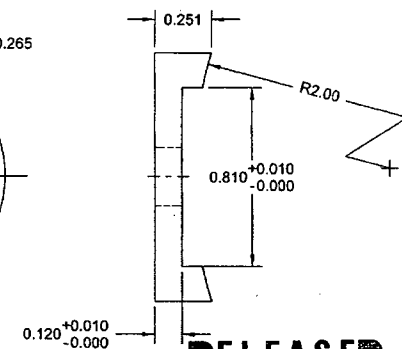
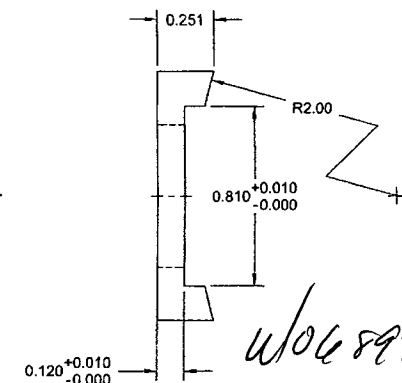
**D3417-3 WASHER**



**D3417-5 WASHER**



**D3417-7 WASHER**



**RELEASED**  
2010-09-15

DESIGN	SC	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

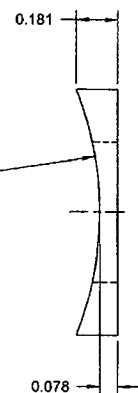
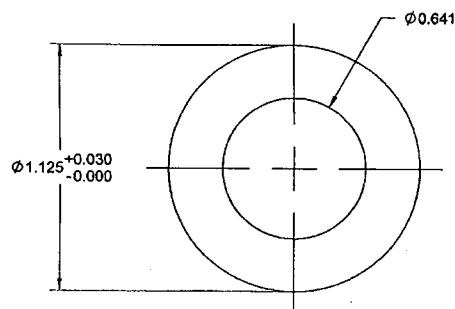
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**NOTE:** Date & initial all entries





**D3417-9 WASHER**



*W/O 68772*

**RELEASED**  
2010-09-15

DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. <b>D3417</b>	REV. F
MFG. APPR.		TITLE <b>WASHER</b>	SHEET 3 OF 3
APPROVED		SCALE	NTS
DE APPR.		DATE <b>10.07.26</b>	
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